

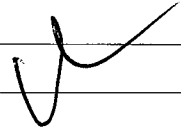
Work Order ID 121296

June 20-14 1:37:55 PM

\*121296\*

Page 1

Item ID: D2583 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Latch Bracket  
 Start Date: 6/20/14 Start Qty: 24.00 \*24\* Cust Item ID:  
 Required Date: 6/27/14 Req'd Qty: 24.00 \*24\* Customer:  
 Reference:

Approvals: Process Plan:  Date: Tooling: Date: Run Start \*NR1\*  
 QC: Date: SPC (Y/N): Date: Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2583	Rev B

100 0.00 DAS 23 9-89 14-06-23  
 \*100\* FLOW WATER JET  
 Waterjet Memo 0.00  
 FLOW CNC Waterjet 1-Cut as per Dwg D2583 Dwg Rev: B Prog Rev: B 2-  
 Deburr if necessary

110 0.00 DAS 23 9-89 14-06-23  
 \*110\* QC2- Inspect parts off machine FAI/FAIB  
 QC Memo 0.00  
 Quality Control

120 0.00 DAS 27 9-89 14-06-23  
 \*120\* QC8- Inspect parts - second check  
 QC Memo 0.00  
 Quality Control

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Stop \*NR2\*

DeburrForm on CNC Brake as per Dwg D2583

**DAS**  
**30**  
**9-89**

### Quality Control

DAS  
27  
9-85

## Hand Finishing

20

24 7647.2

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Start Date: 6/20/14 Start Qty: 24.00 **\*24\*** Cust Item ID:  
Required Date: 6/27/14 Req'd Qty: 24.00 **\*24\*** Customer:  
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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 <b>*160*</b> Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per OSI005 4.3-Alum <i>M 108989</i> Memo START TIME: <i>12:20</i> OVEN TEMPERATURE: <i>320</i> FINISH TIME: <i>12:50</i>	0.00 0.00				<i>24</i>	<i>0</i>	<i>14-7-2</i>	<i>24 00</i>
170 <b>*170*</b> QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00		<i>EB</i> <i>14/02/02</i>	DAS 27 9-89	<i>(24)</i>			
180 <b>*180*</b> Packaging Packaging	Identify as per dwg & Stock Location: <i>5TH82</i> Memo	0.00 0.00				<i>24x</i>	DAS 28 9-89	<i>JUL 02 2014</i>	

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Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
*190*									
QC	Memo	0.00							
Quality Control									

NF 14-7-03

# Picklist Print

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Page 1

Work Order ID: 121296

**\*121296\***

Parent Item: D2583

**\*D2583\***

Parent Item Name: Latch Bracket

Start Date: 6/20/14

Required Date: 6/27/14

Start Qty: 24.00

Required Qty: 24.00

Comments: IPP: C00.11.01Removed P/O for Powder Coat- in house processDM  
IPP: D06.07.21 Waterjet EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M5052H32S.040

Purchased

No

100

sf

154.7600

0.1169

3

DAS  
23  
9.89

**\*M5052H32S 040\***

**\*\***

14-06-23

5052-H32 .040 Sheet

Location

Loc Qty

Loc Code

MAT022

154.76

122406

9.8

124445

1.4

124573

2

m126593

30.06

m128852

31.5

m129530

80

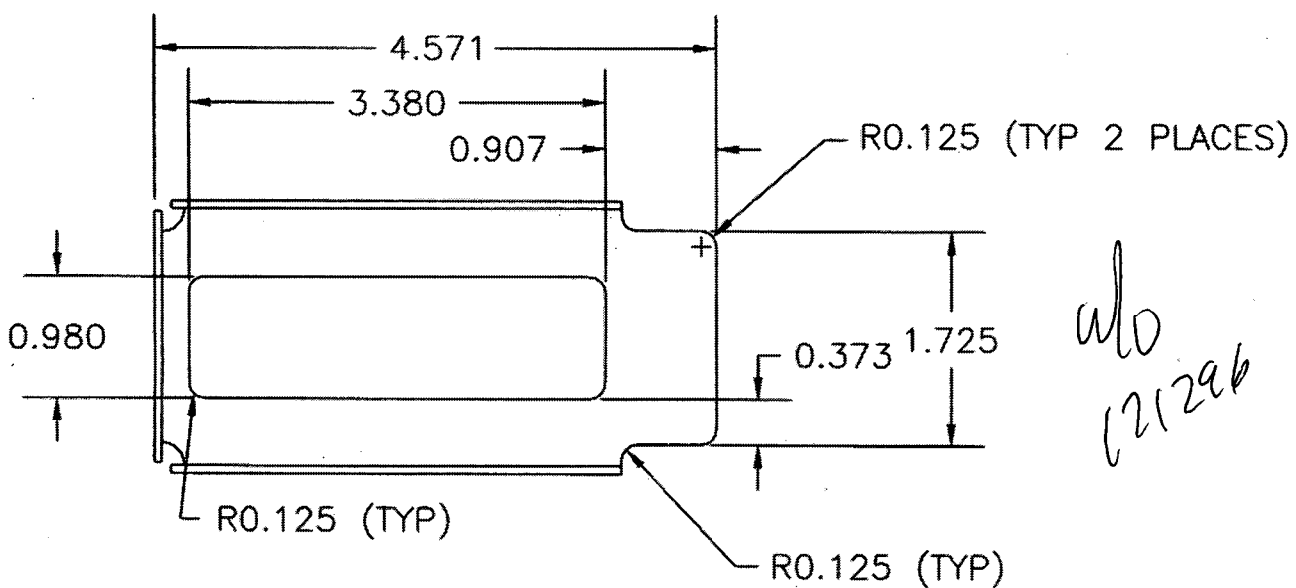
128852





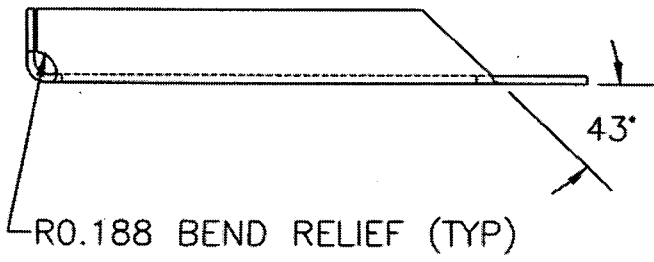
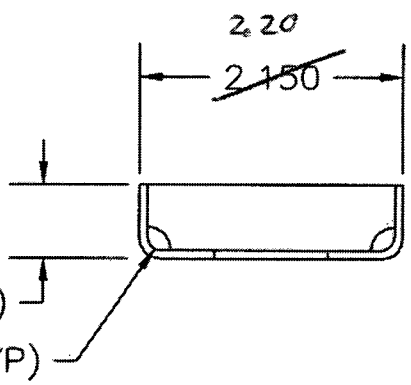
RELEASED  
KE 99.02.25

DESIGN	MIKE M.	DRAWN BY	RF	DART AEROSPACE LTD
CHECKED	CP	APPROVED	KE	HAWKESBURY, ONTARIO, CANADA
DATE	99.02.22	TITLE	D2583	REV. B
			LATCH BRACKET	SHEET 1 OF 1
			NEW ISSUE	SCALE 2:3
			CHANGE OF FINISH (PER TSR A887)	



also  
12/29/6

KE 99.02.26



MATERIAL: 5052-H32 (QQ-A-250/8) 0.040 THICK  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED